

Fig. 1

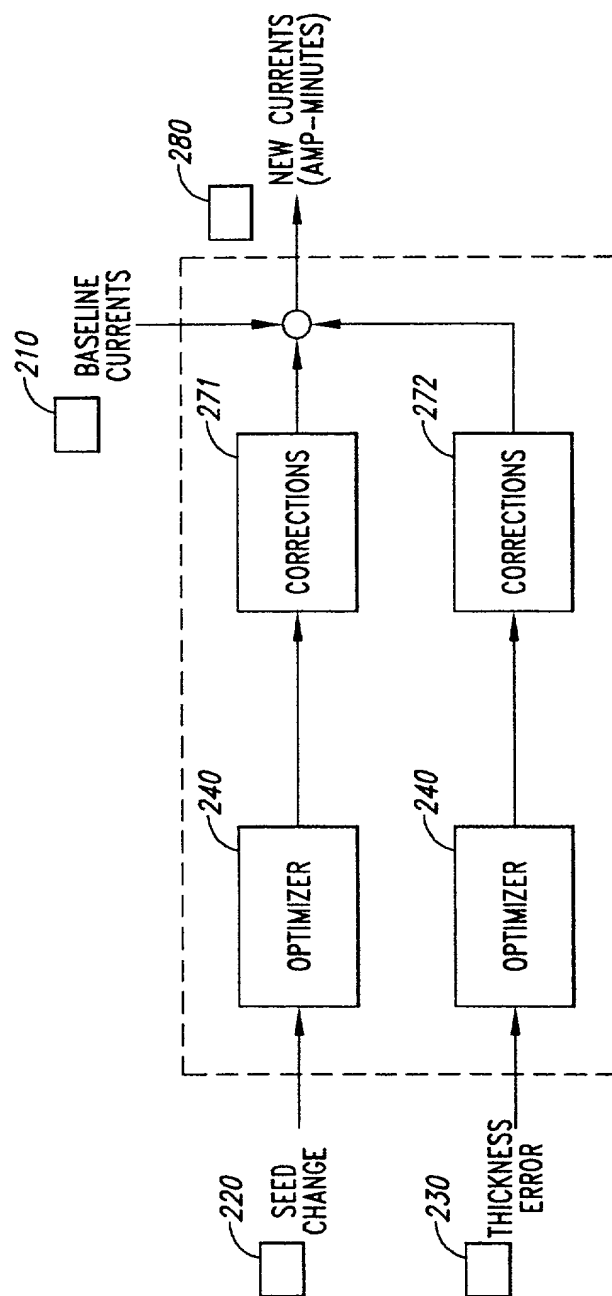


Fig. 2

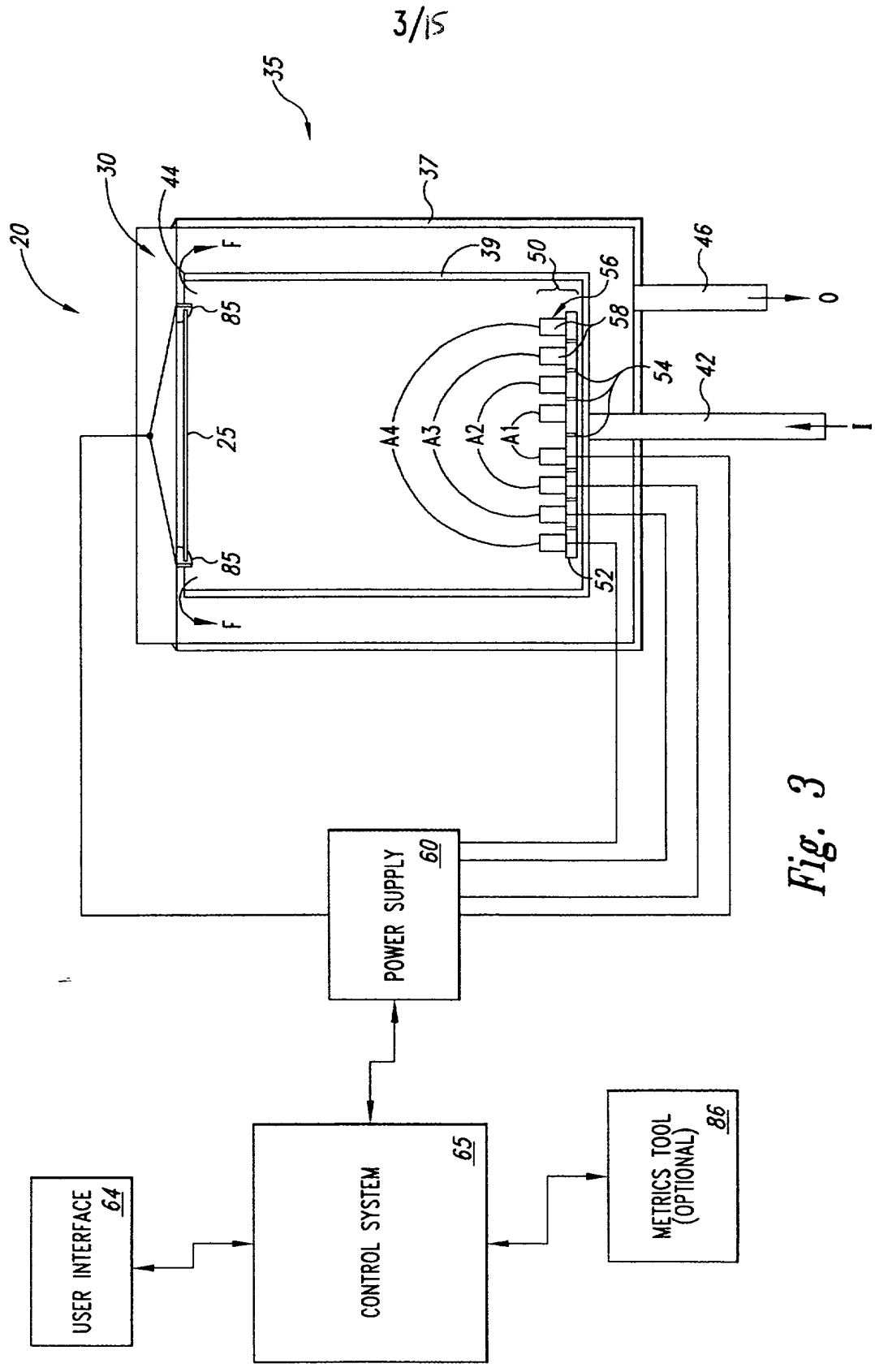
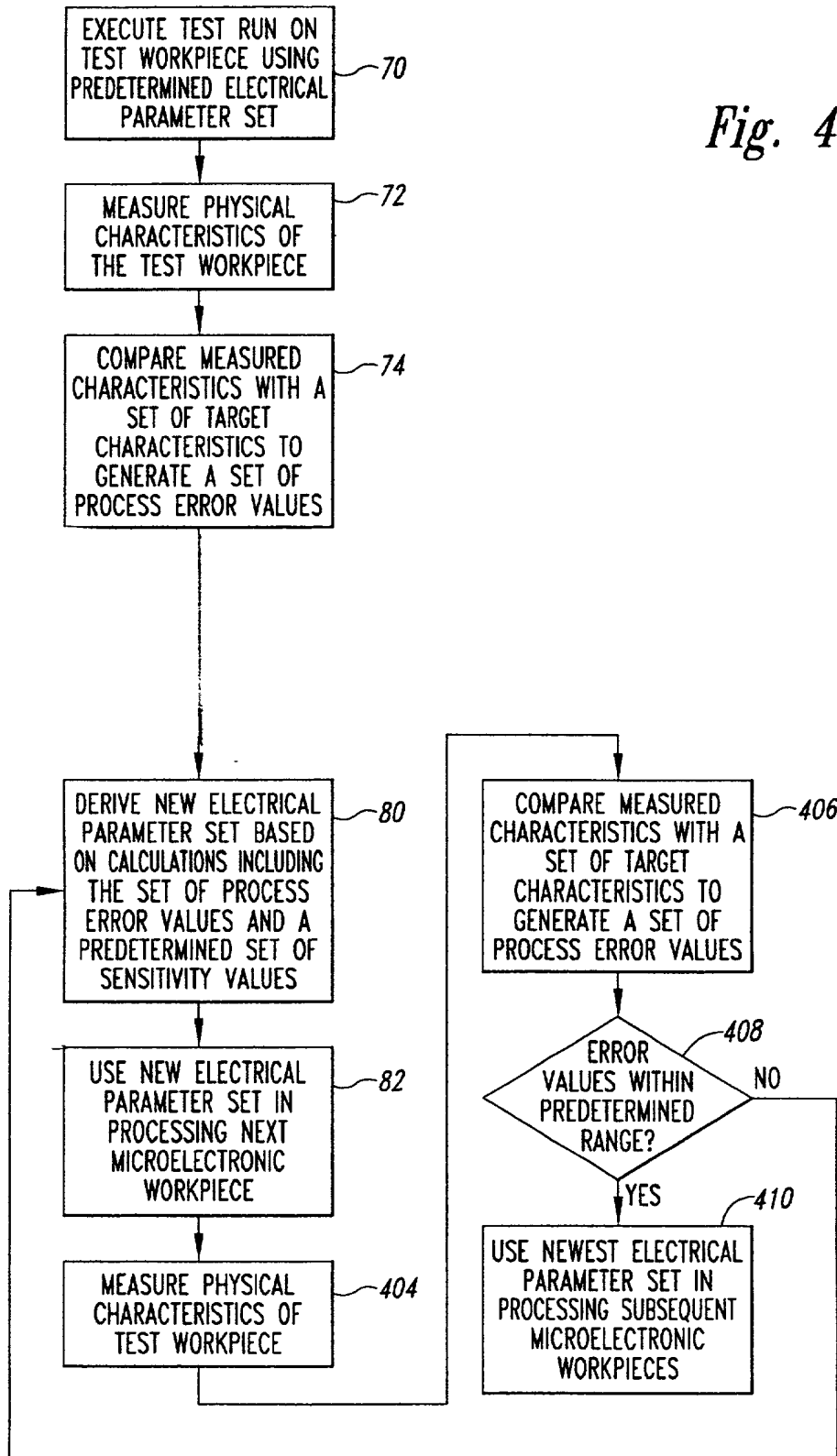


Fig. 3

Fig. 4



5/15

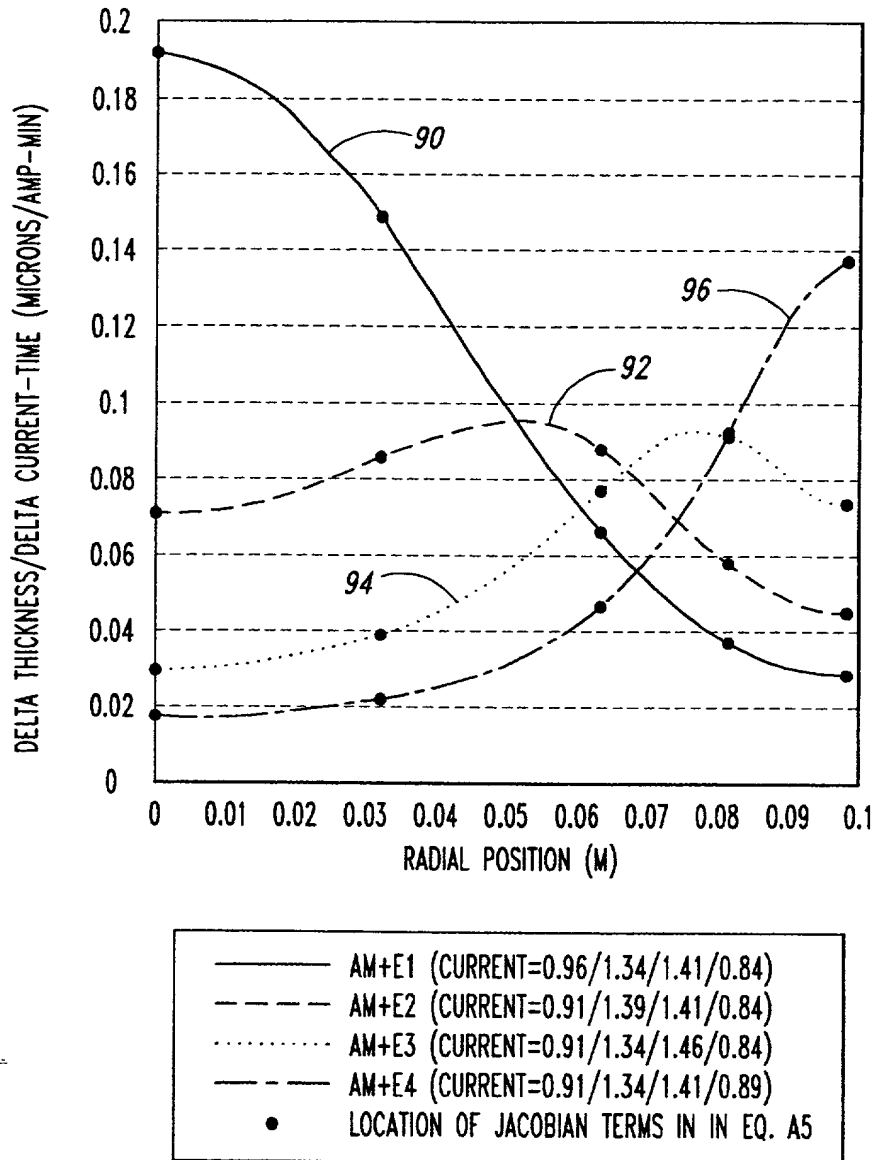


Fig. 5

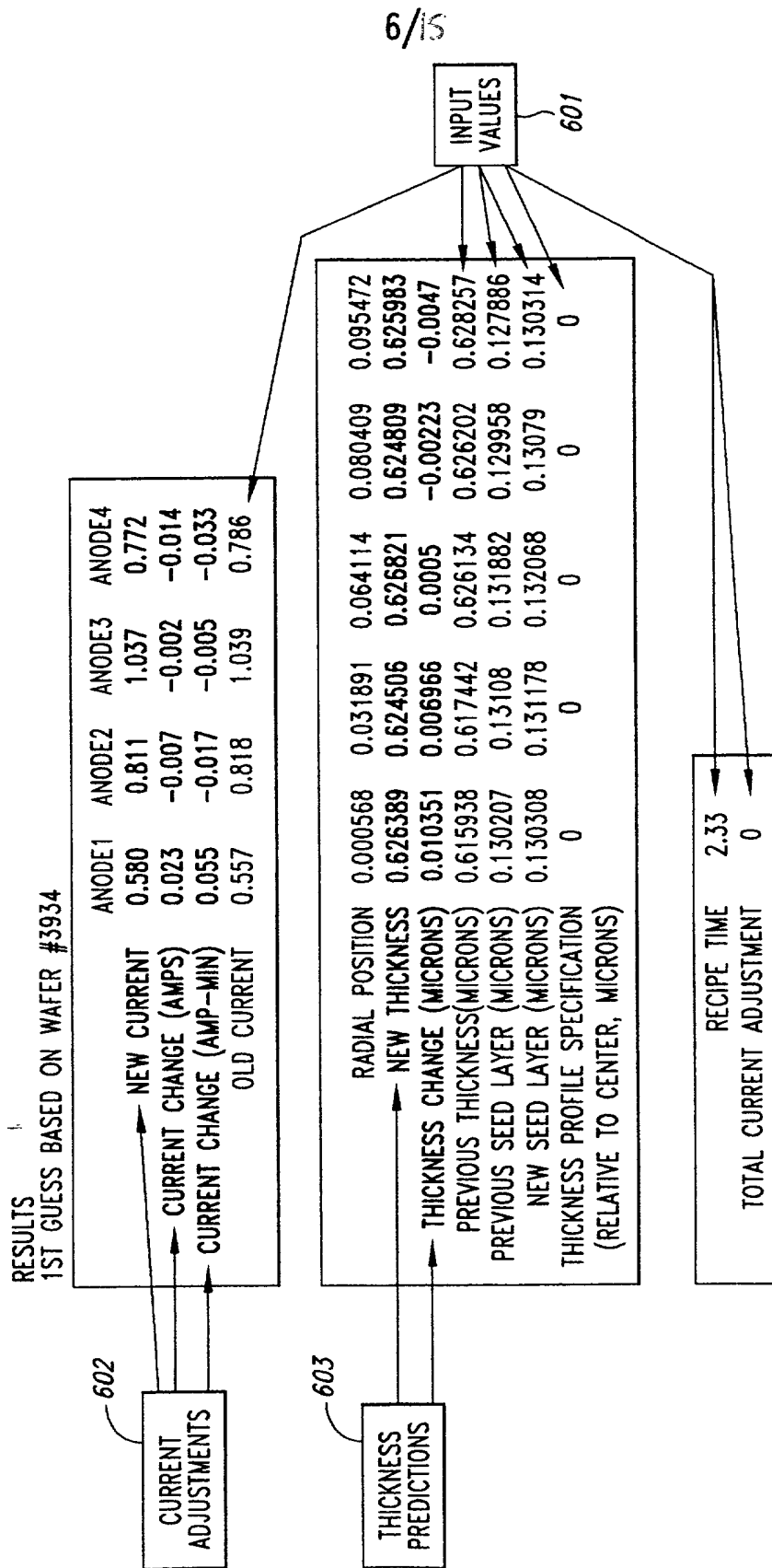


Fig. 6

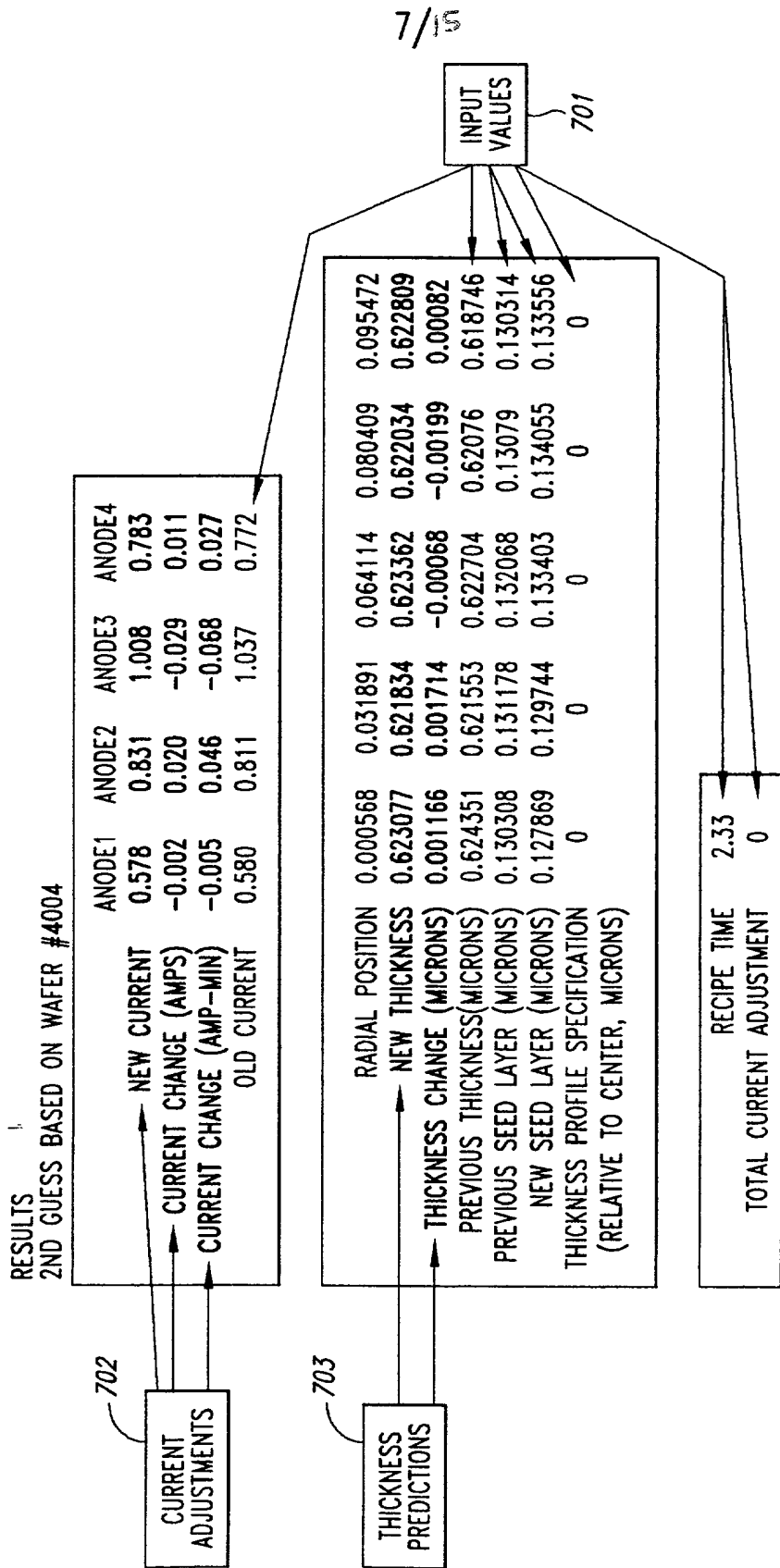
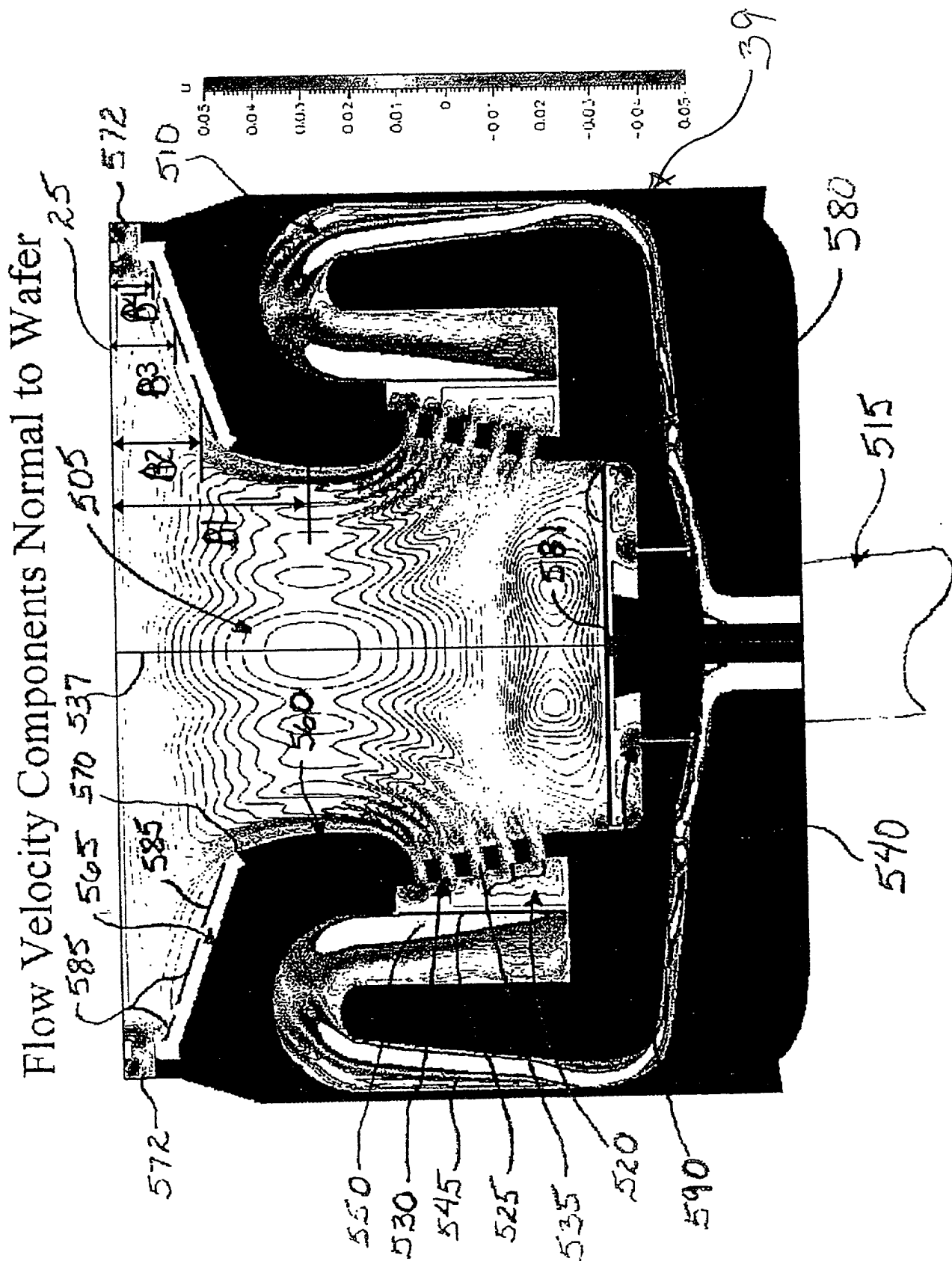


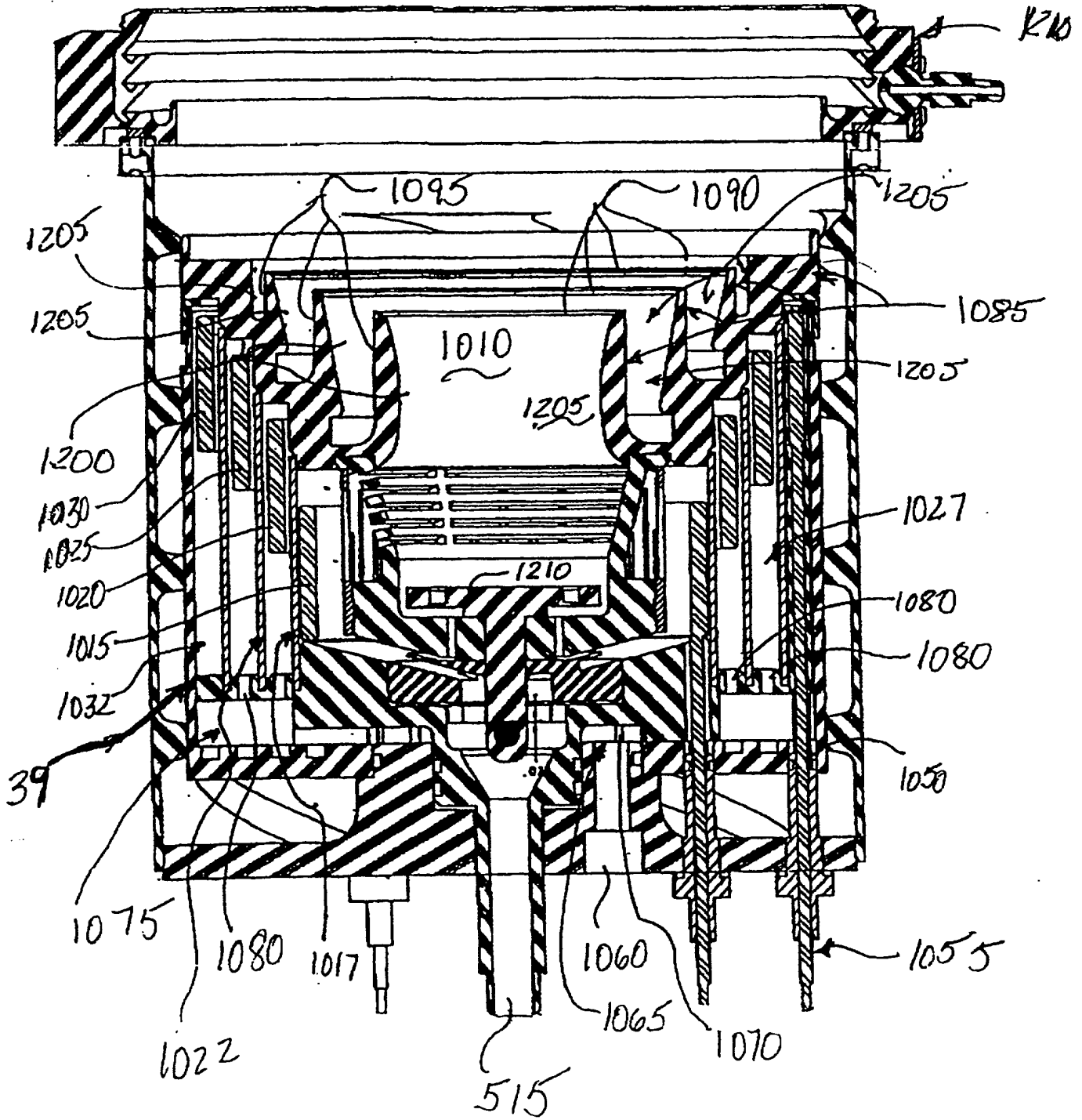
Fig. 7

FIGURE 8



9/15

FIGURE 9



10/15

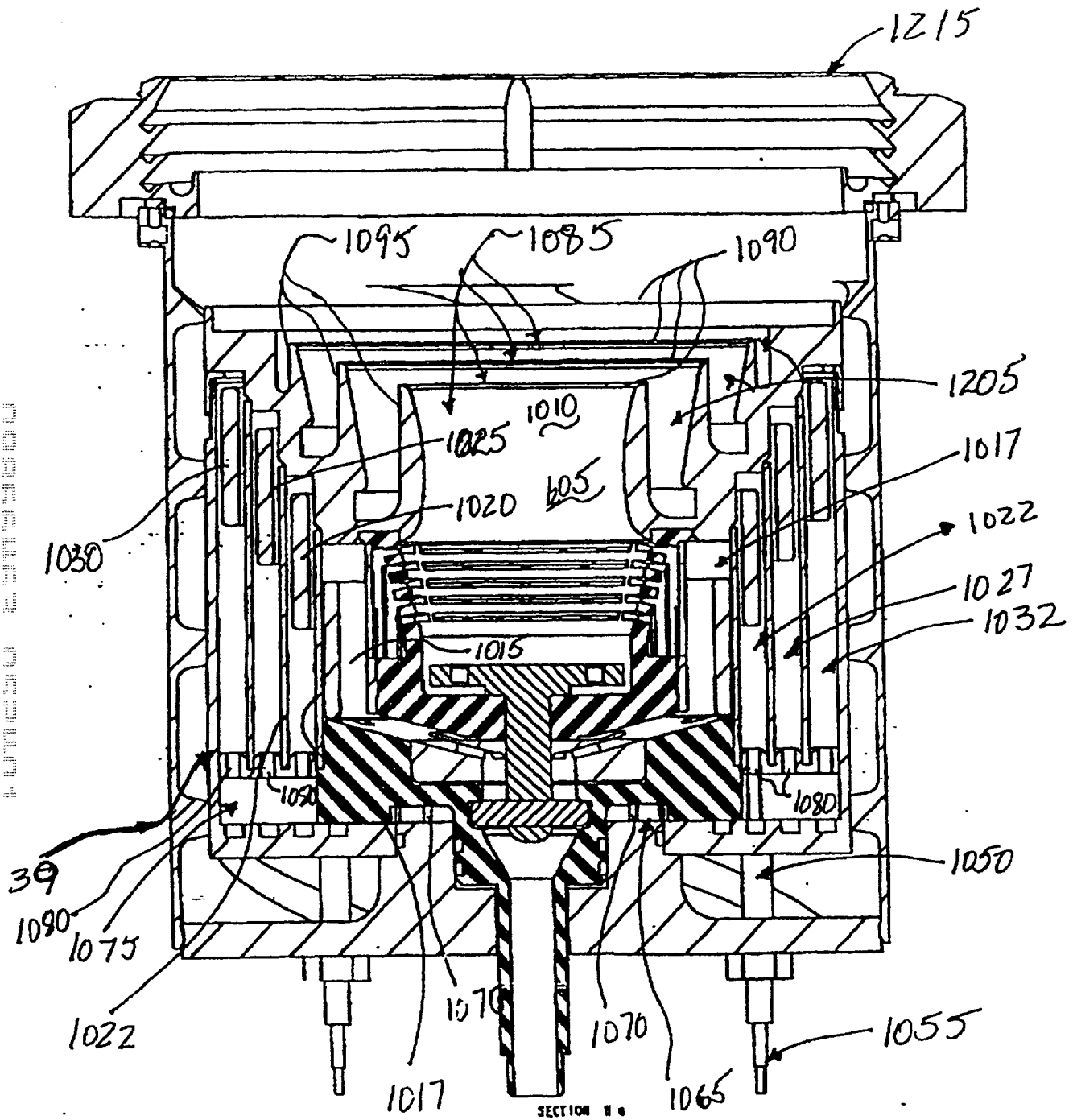
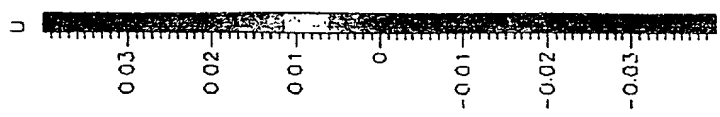
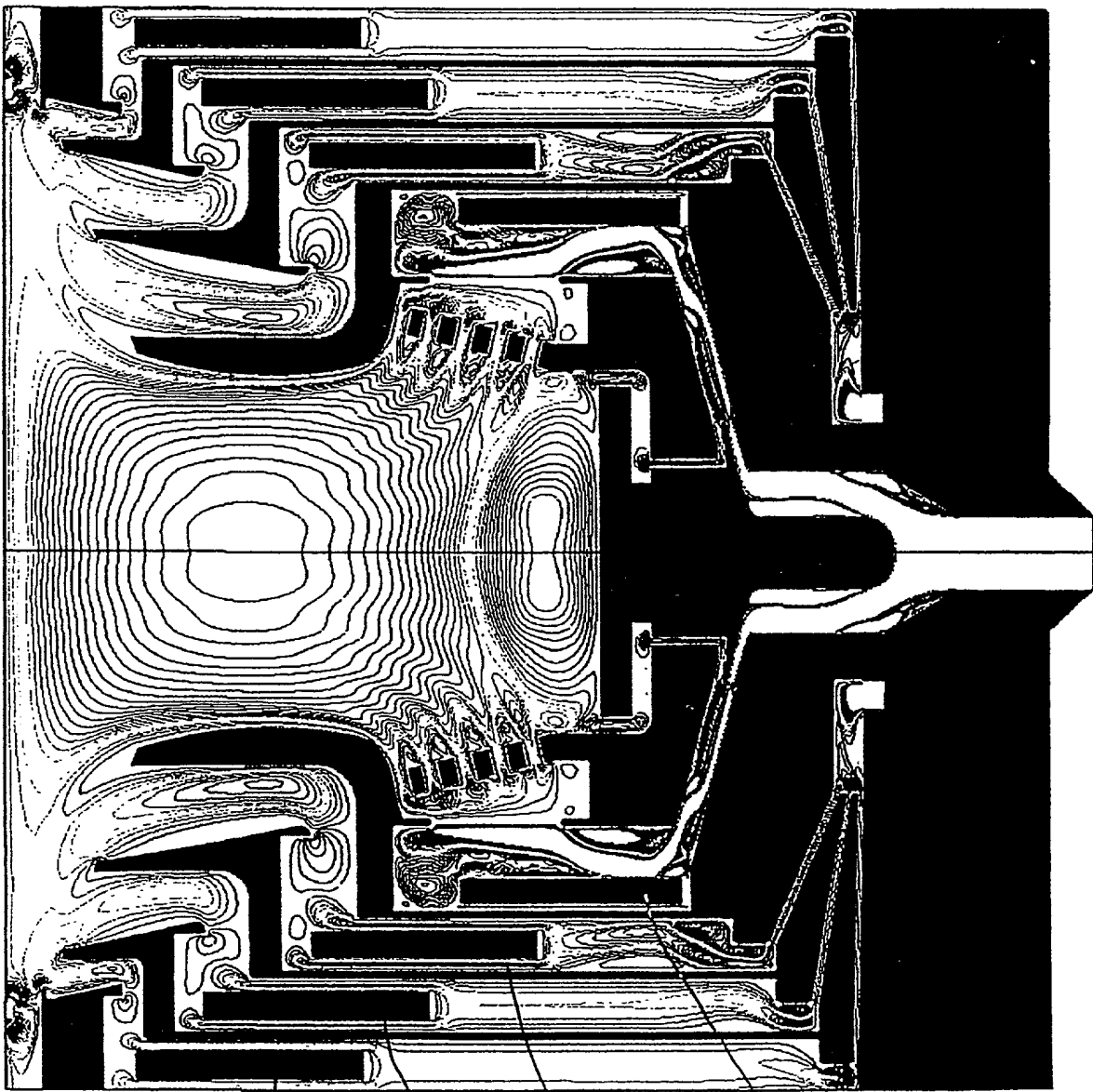


FIGURE 10

Workpiece Normal Velocity Contours

Two Flow Paths Refreshing Anodes

(Scale -0.05 to 0.05 m/sec)



39

1030

1025

1020

1015

1010

11/15

FIGURE 1

Workpiece-Normal Velocity Contours Single Flow Path (No Flow Over Anodes)

(Scale -0.05 to 0.05 m/sec)

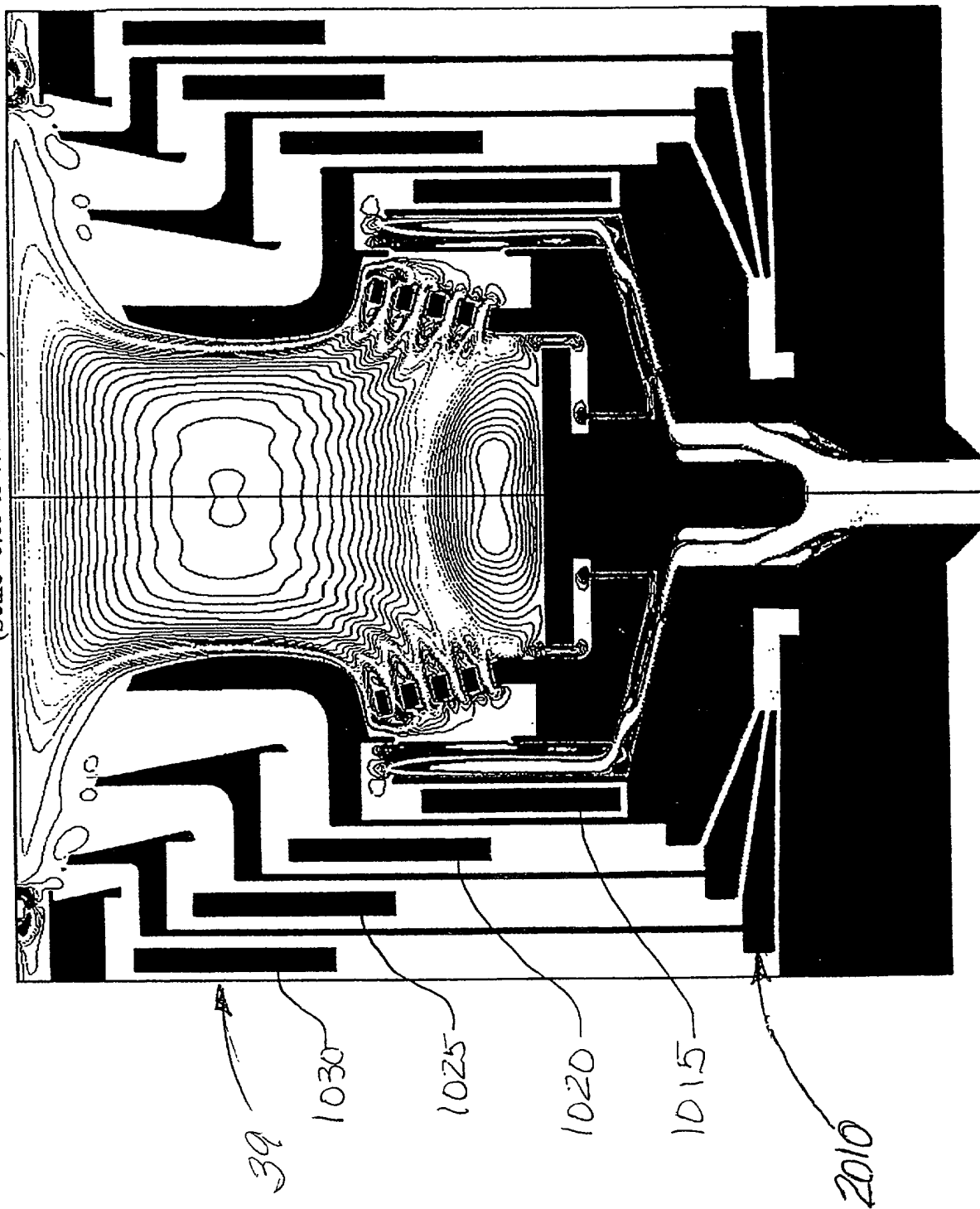


Figure 12

12/15

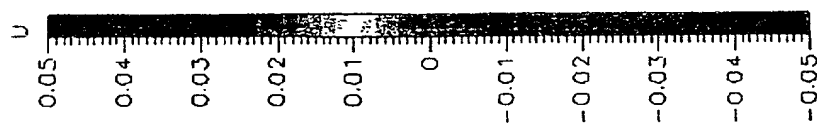
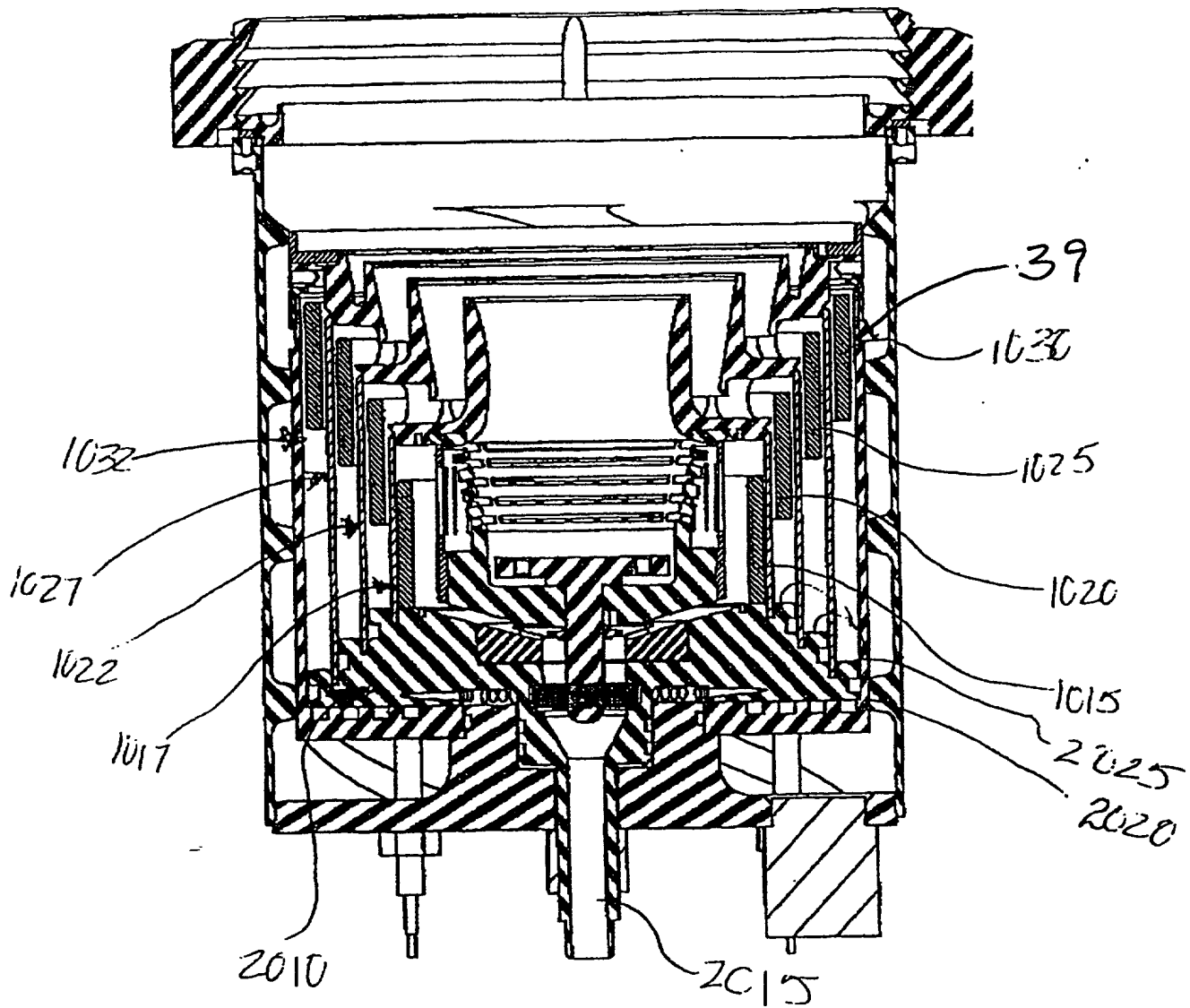


FIGURE 13



14/15

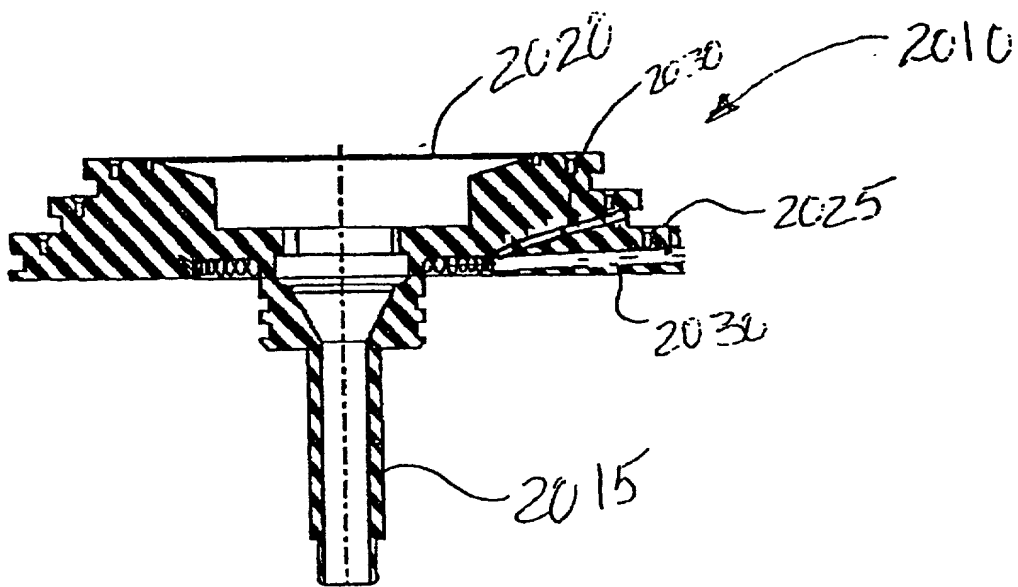


FIGURE 14

FIG. 15

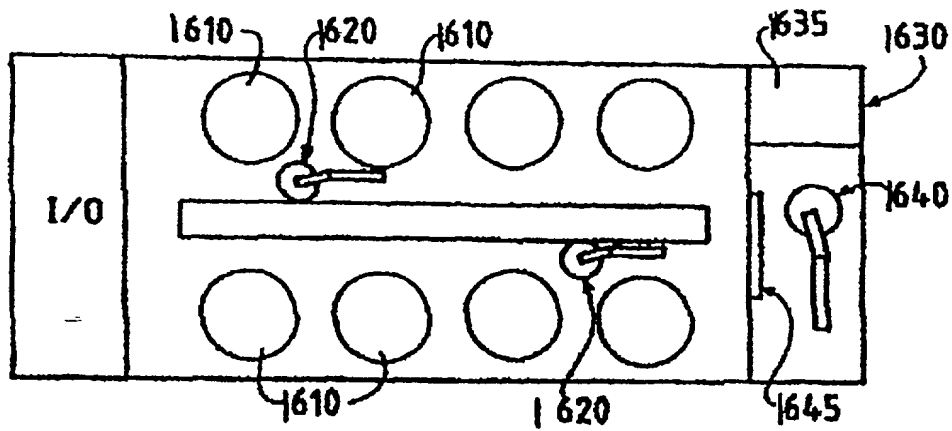
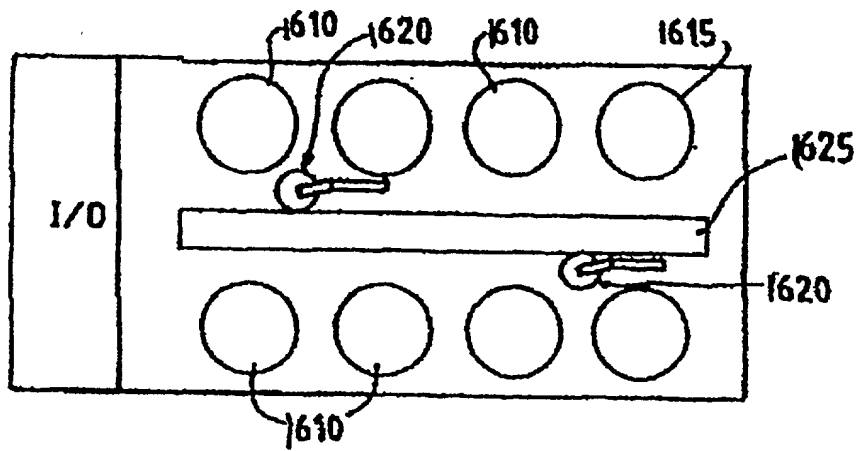


FIG. 16